

Date: Monday, 3/13/2006 7:30:21 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP LEG
Job Number	: 26211C		
Estimate Number	: 10382		
P.O. Number	: N/A	Part Number	: D30655
This Issue	: 3/13/2006 S.O. No. : N/A	Drawing Number	: D3065 REV. A2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: A2
Previous Run	: 24408C	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 3/30/2006
Checked & Approved By	: <u>06.03.13</u>	Qty:	120 Um: Each
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S080	5052-H32 .080 Sheet
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Comment: Qty.: 1.1338 sf(s)/Unit Total: 136.0548 sf(s)

Material: 5052-H32 (QQ-A-250/8) 0.080" thick  
 (M5052H32S.080)

Batch:

M100742 4x8 M10012 4x8  
M100682 4x8 06 05 09 (120)

2.0	SHEAR	SHEAR
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Comment: SHEAR

Cut blank: 16.61" x 8.51" Grain along 8.51"

3.0	HAAS1 <u>Waterjet</u>	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Cut per Machine as per Folio FA179 and Dwg D3065  
 Stack of 10  
 Identify as D3065-5

Prog Rev: A2  
 Dwg Rev: A2

06 05 09 (120)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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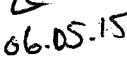
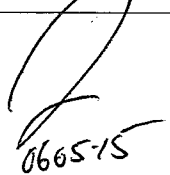

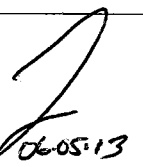

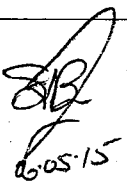
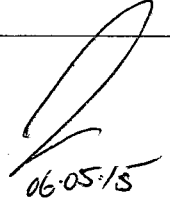
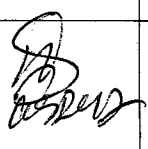


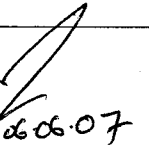

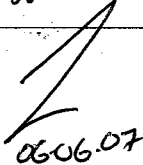


Comment: SECOND CHECK

06 05 15 (111)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/06/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-05-13	3	Dim for slot .213 <del>is</del> is under by .003, on a +.005 - 0.0 tolerance.		Slot is acceptable. <del>Modify program.</del>	 06-05-15	 06-05-15	 06-05-15	 06-05-13
06-05-15	3	10 parts scrap. 6 with hole damage from water set cutting over the ribs on the back 4 with blow outs in the hole causing delamination of mat'l.		Scrap: destroy	 06-05-15	 06-05-15	 06-05-15	 06-05-15
06-06-07	5	Holes found too small of <del>0.005</del> D3065-5. .125 roughly <del>0.002</del> .002 → .003 under size.		Open manually AS necessary and debur, touch-up holes with slope AS per QSI 005 4.1.	H.M. 06/06/07	 06-06-07	 06-06-07	 06-06-07

NOTE: Date & initial all entries

Date: Monday, 3/13/2006 7:30:22 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 26211C

Part Number: D30655

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

H.M. 06/05/17

(111)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M.F. 06/05/24  
H.M. 06/05/24

(40)  
(111)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

SB 06/06/05

111

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/06/05

111

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SB 06/06/08

(111)

Job Completion



W 06/06/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

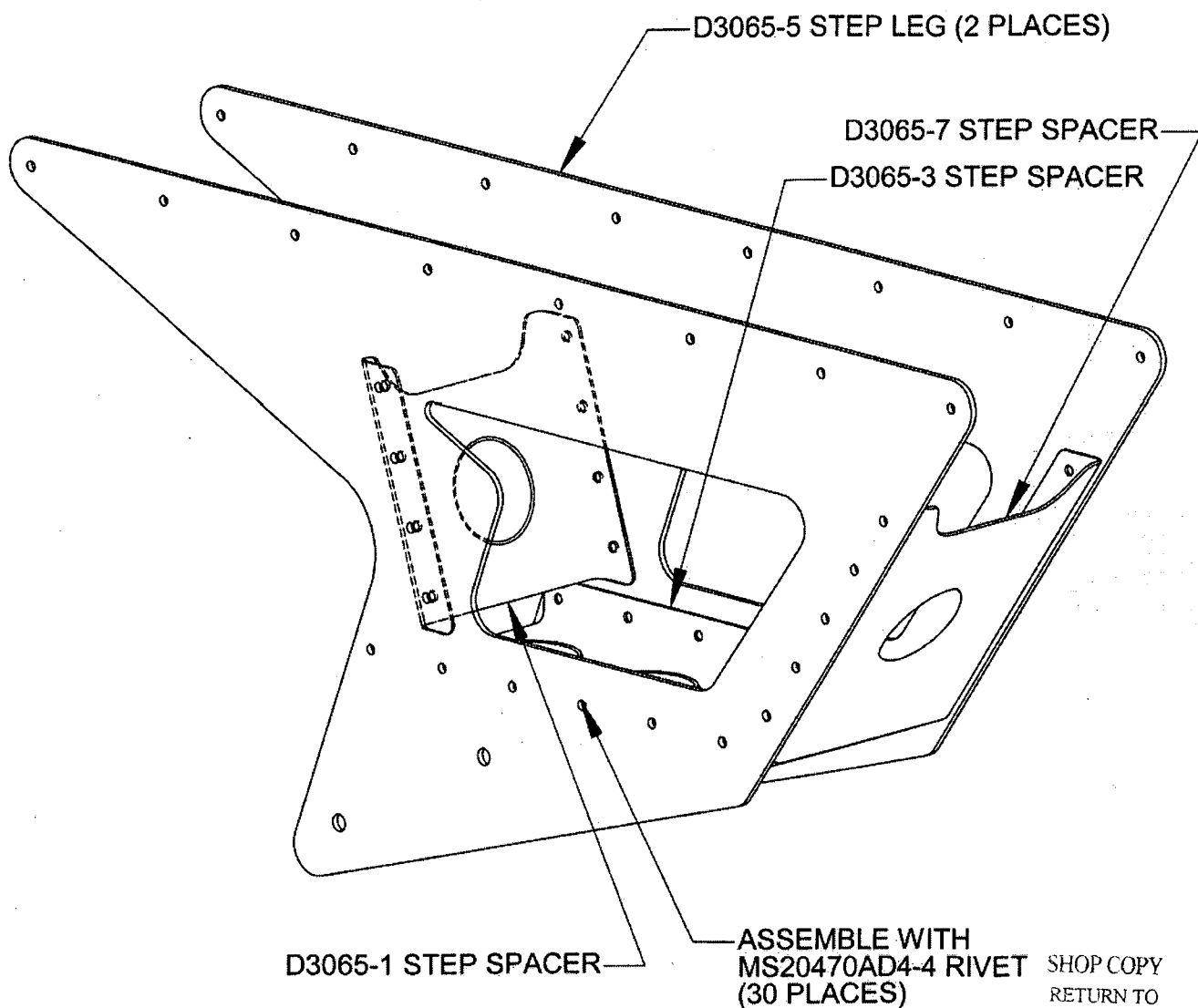
NOTE: Date & initial all entries





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DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
A1	03.02.13 <i>CP</i>	ADD SLOTS TO D3065-5	
A2	03.02.27 <i>CP</i>	0.551 WAS 0.410	

RELEASED  
02.09.20 *#*



## D3065-041 STEP LEG ASSEMBLY

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NO. 26211C

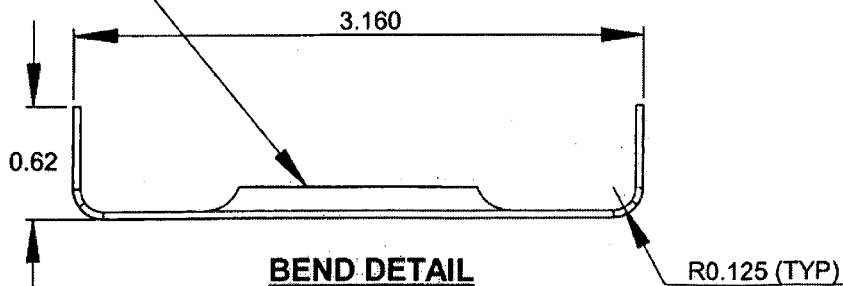
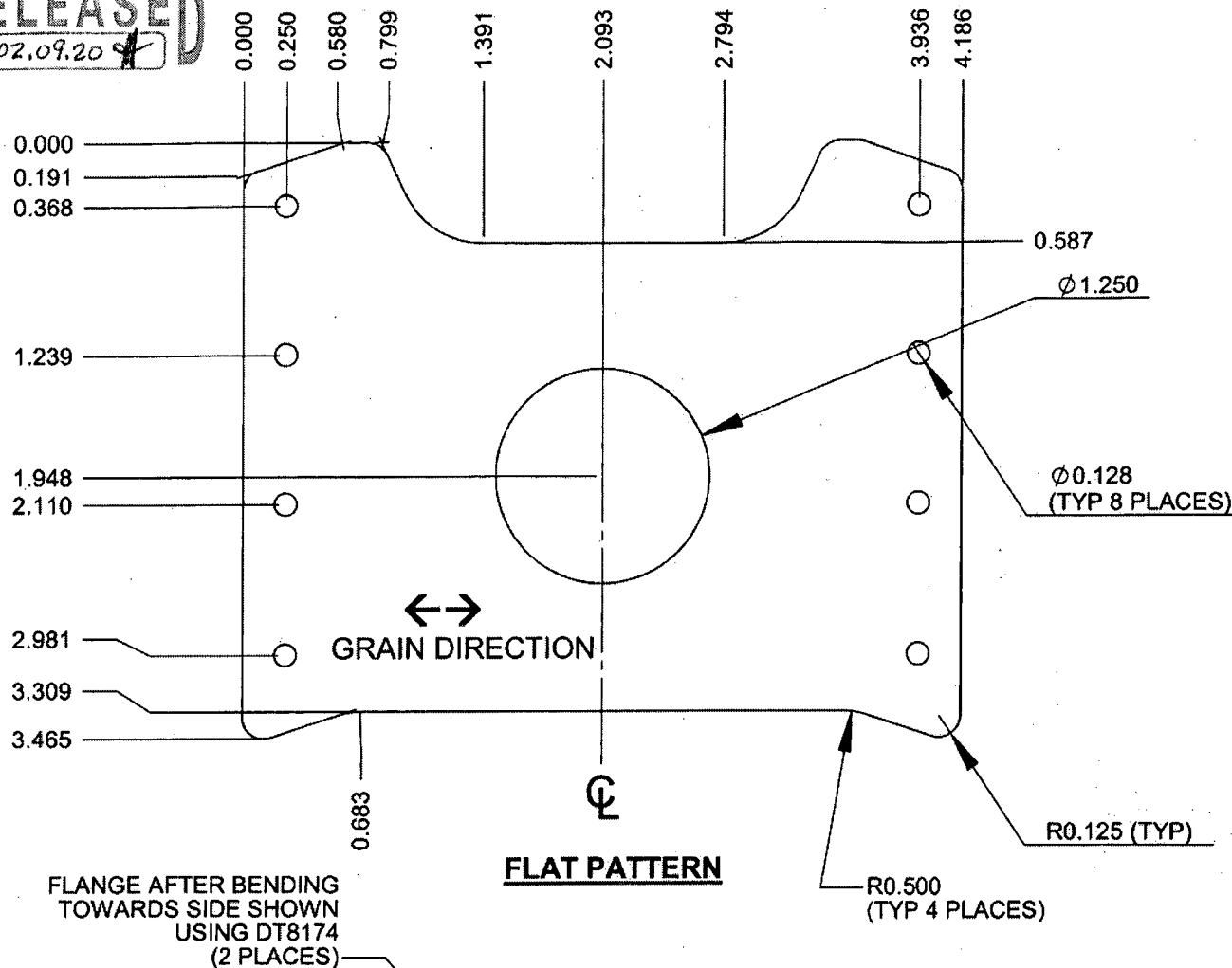
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DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:1

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02.09.20 *[Signature]*



### D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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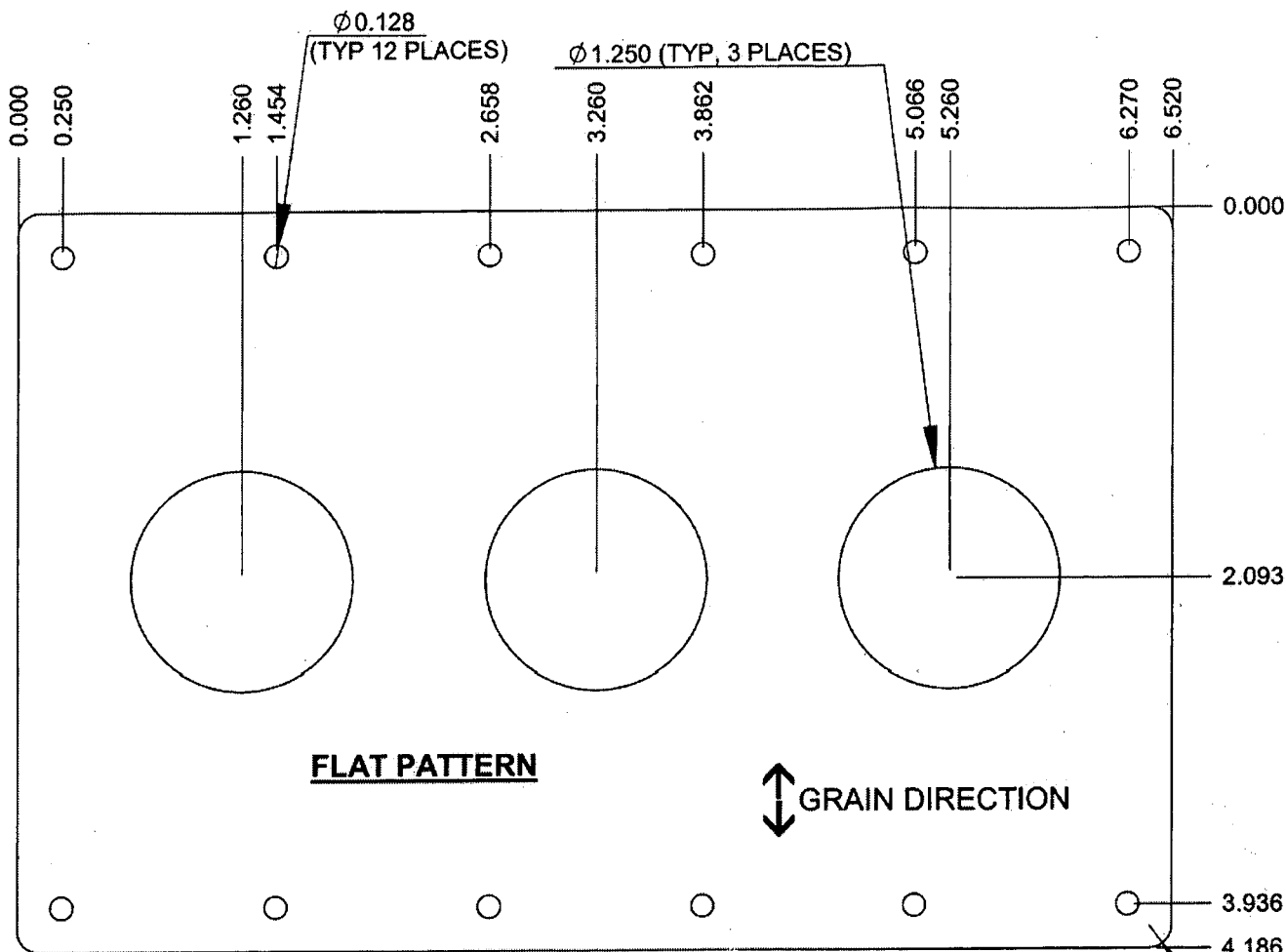
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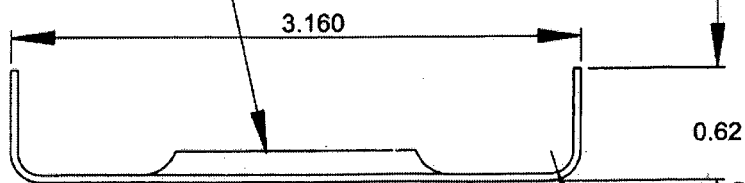
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DATE <b>02.09.11</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:1



**FLAT PATTERN**

↑ ↓  
**GRAIN DIRECTION**

FLANGE AFTER TOWARDS SIDE  
SHOWN USING DT8174 (3 PLACES)



**BEND DETAIL**

**D3065-3 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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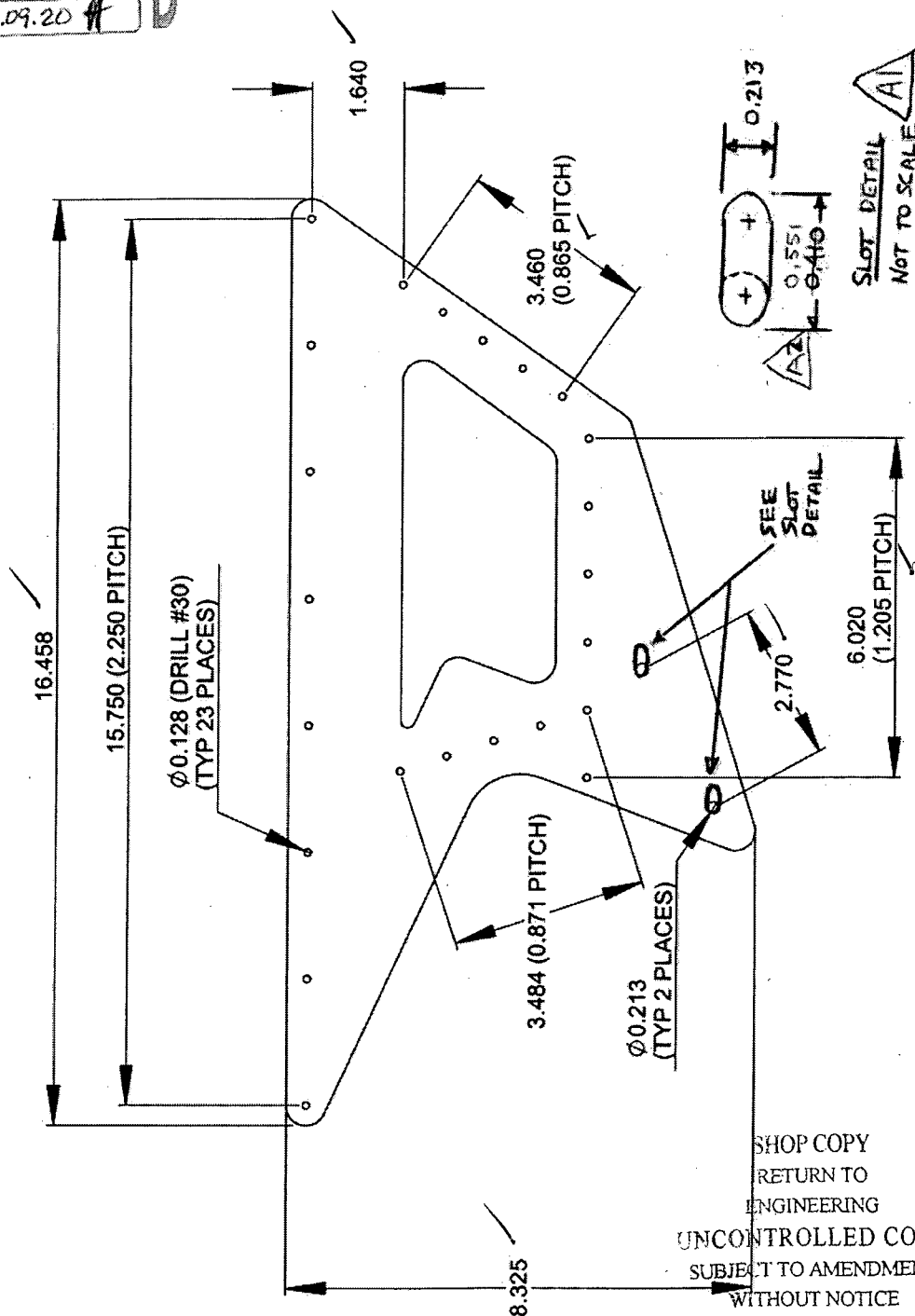


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02.09.20 #



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**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

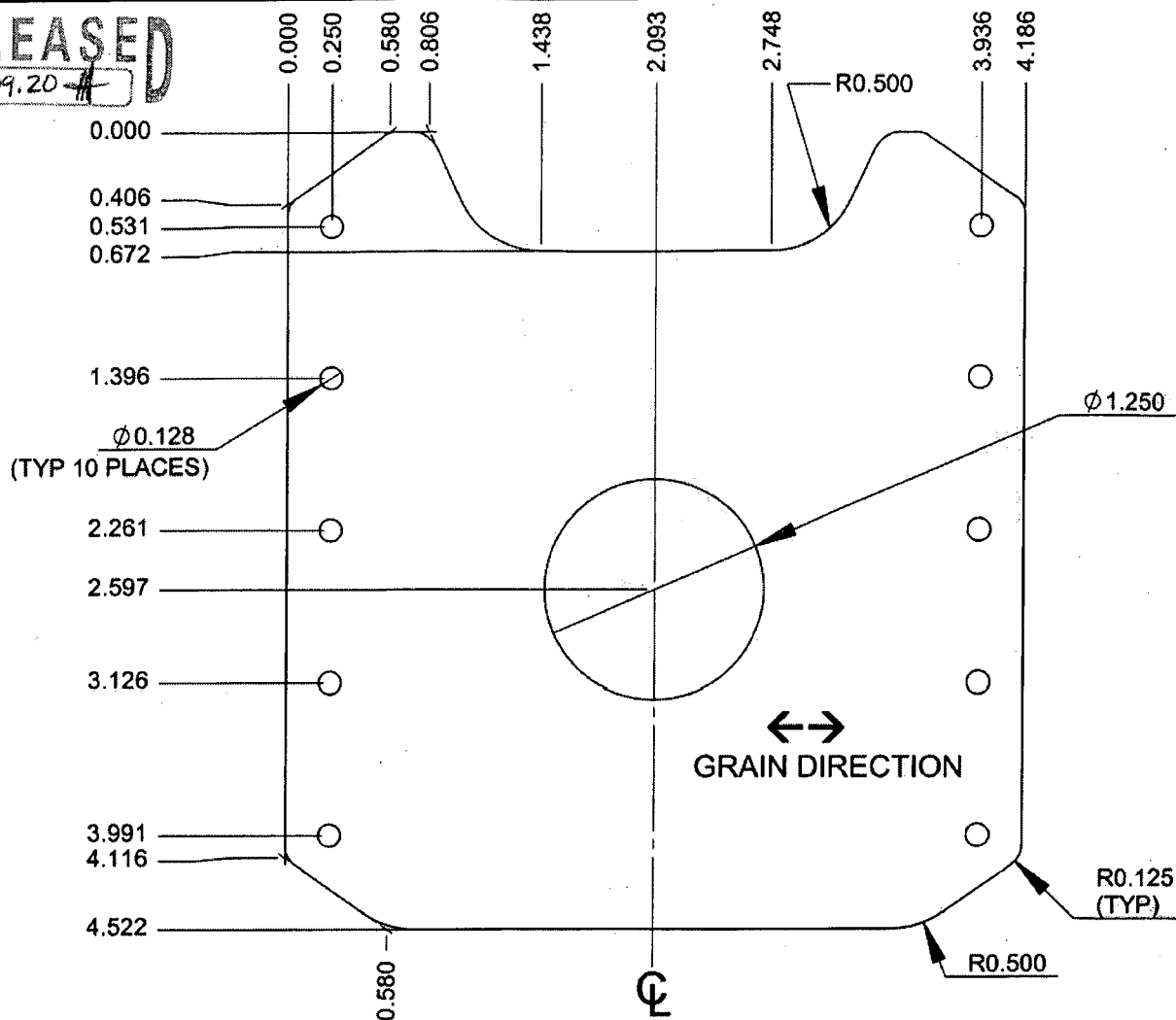
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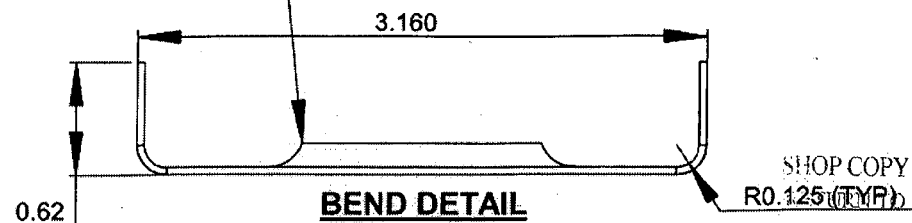


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DATE <b>02.09.11</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:1

RELEASED  
02.09.20 *#*



FLANGE AFTER BENDING TOWARDS  
SIDE SHOWN USING DT8174 (2 PLACES)



### D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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